

Date: Friday, 9/21/2007 1:17:06 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 34806		
Estimate Number	: 12786		
P.O. Number	: <i>N/A</i>	Part Number	: D35645
This Issue	: 9/21/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3564 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 9/21/2007 Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 33802	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/5/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	30 Um: Each
Comment	: Est Rev:A New Issue 07-03-08 ec : Est Rev:B As per Rev C 07-07-09 JLM : Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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*23 = 25.517 sf**27.7693*

Comment: Qty.: 1.1099 sf(s)/Unit Total : 33.2955 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: *m105 824**1B07-10-4**m105130*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3564

Dwg Rev: *C**1B 07-10-4*Prog Rev: *C**(30)*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*1B 07-10-4*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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*~~1B 07-10-4~~*

Comment: SECOND CHECK

counter
SA 07/10/05
(+30)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT *8179* and DT *8155*Form Joggle as per Dwg D3564 on brake using Jig DT *8157**SA 07/10/17*
(30)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/18/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:17:06 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 34806

Part Number: D35645

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

counter
07/10/17 *(30)*

7.0

POWDER COATING

POWDER COATING



M 104846



(30x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-l 07/10/18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



SS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-10-18 *(30)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP 15

m-l 07/10/18

(30x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/17

Job Completion



U 07-10-19

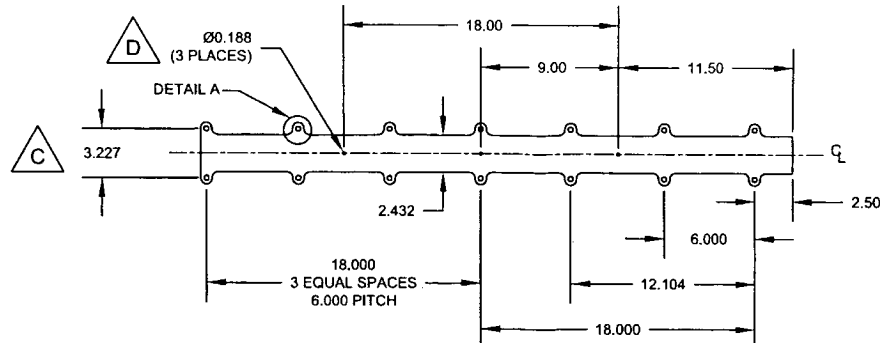
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

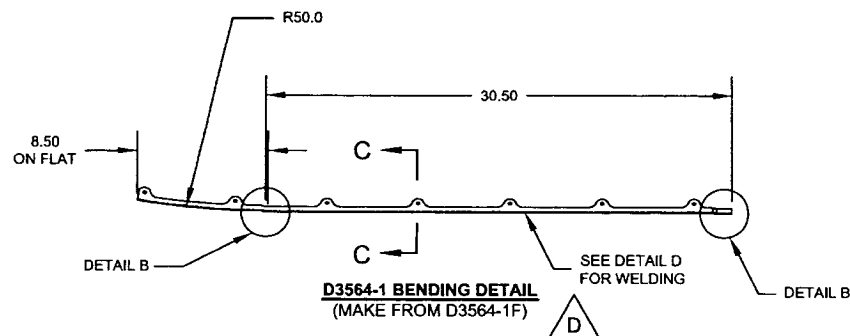
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

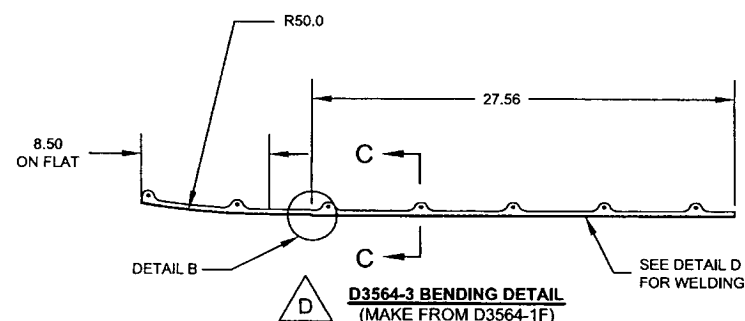
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

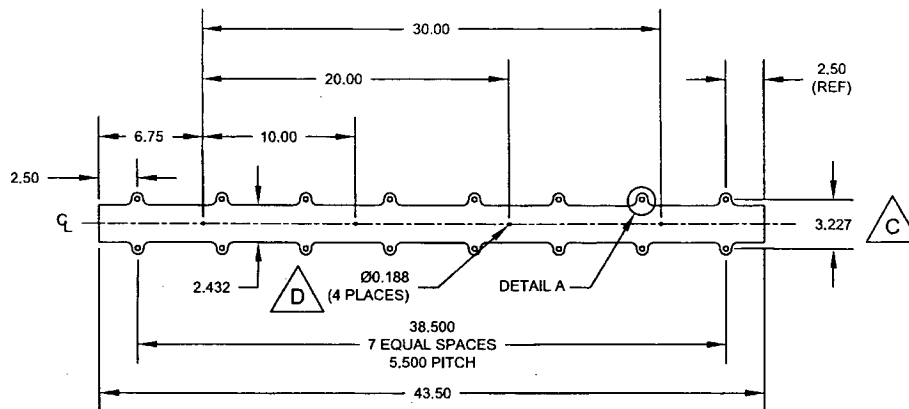
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT CL

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

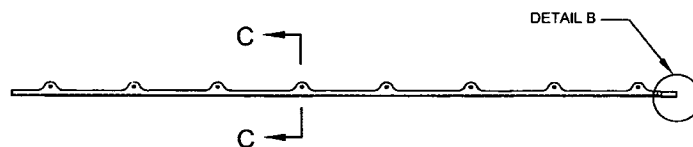
NO. 34800
WORK ORDER
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ENGINEERING
RETURN TO
SHOP COPY

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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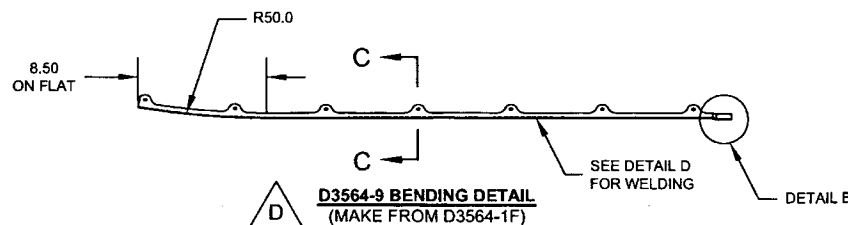
RELEASED
07.09.04



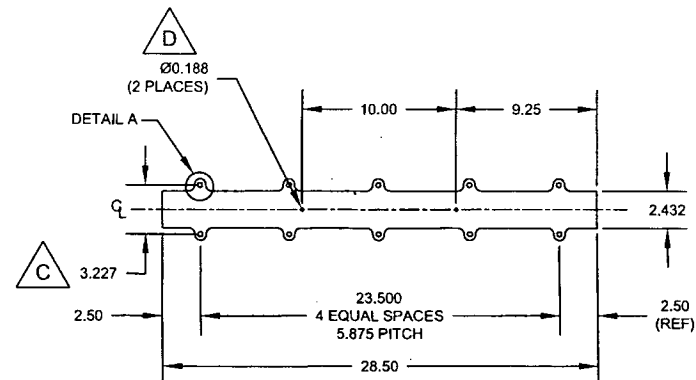
D3564-5F FLAT PATTERN



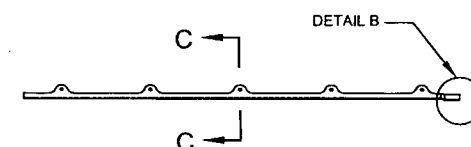
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



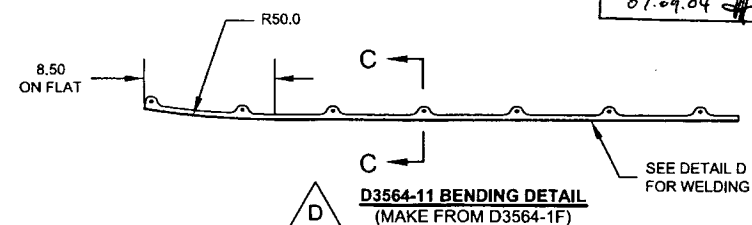
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



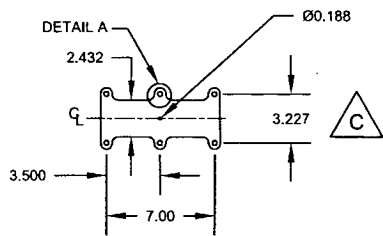
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

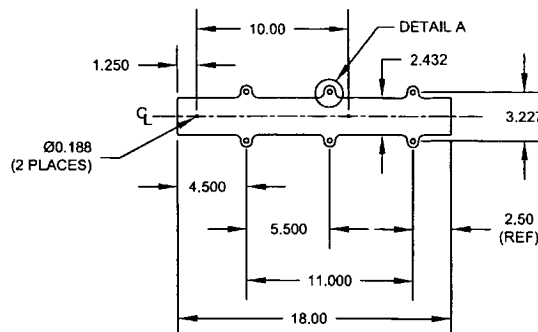
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NO. 34860
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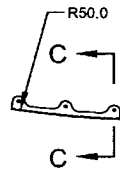
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
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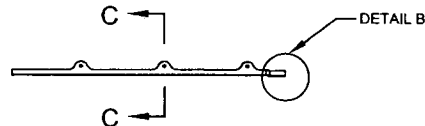
D3564-13F FLAT PATTERN



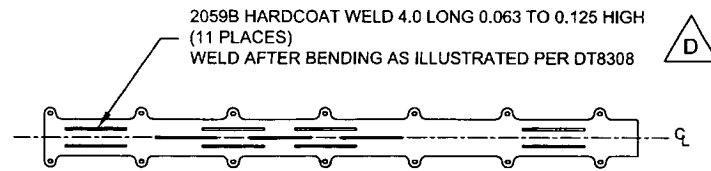
D3564-15F FLAT PATTERN



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



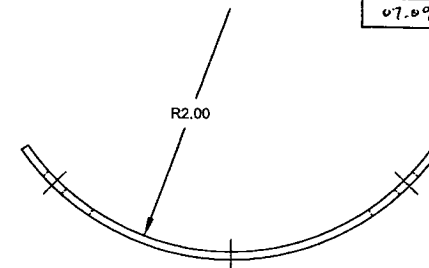
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



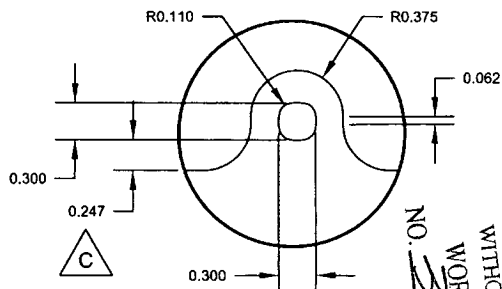
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

RELEASED

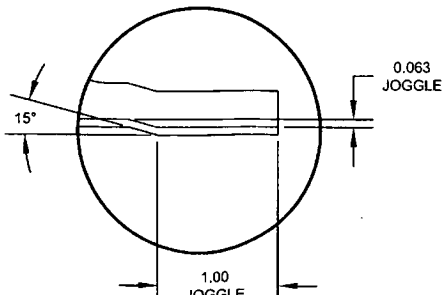
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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NO. 3480

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DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:
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